



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

007187

DSI 9815-011
Job Sheet 187928



Part No: DSI 9815-011

Job Qty: 15 pcs

Part Name: Replacement Receptacle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/21/18

Job Tracking No:

Due Date: 12/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DSI 9815 REV.A IPP REV:A 18.12.21 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
110	Packaging 1 - Pick Kit	15 pcs		12/31/18	0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	
							Packaging 1 - 30	
							Packaging 1 - 31	
							Packaging 1 - 32	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐	Skid-tube ☐ Machining ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																								
Date : _____ Descriptor _____					MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																																								
Root Cause <table style="width:100%;"> <tr> <td style="width:20%;">Operator ☐</td> <td style="width:20%;">Bending ☐</td> <td style="width:20%;">BOM/Route ☐</td> <td style="width:20%;">Process/Surge ☐</td> <td style="width:20%;">Positioned Wrong ☐</td> </tr> <tr> <td>Manufacturing Process ☐</td> <td>Crushing ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Program ☐</td> <td>Outside Tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Cracks ☐</td> <td>Incomplete/Unclear Instructions ☐</td> <td>Direction ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Handling/Preservation ☐</td> <td>Crimp/Kink/Ripple/Wave/Twist ☐</td> <td>Drill Holes ☐</td> <td>Weld ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Material ☐</td> <td>Marks/Chatter ☐</td> <td>Fit/Function ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Product Improvement ☐</td> <td>Mislabeled ☐</td> <td></td> <td>Out of Sequence ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Process Improvement ☐</td> <td></td> <td></td> <td>Off-set/Set-up ☐</td> <td></td> </tr> <tr> <td>Human Factors ☐</td> <td></td> <td></td> <td></td> <td></td> </tr> </table> Other/Details: _____					Operator ☐	Bending ☐	BOM/Route ☐	Process/Surge ☐	Positioned Wrong ☐	Manufacturing Process ☐	Crushing ☐	Broken/Damage/Defect ☐	Program ☐	Outside Tolerance ☐	Equip/Tooling ☐	Cracks ☐	Incomplete/Unclear Instructions ☐	Direction ☐	Drawing ☐	Handling/Preservation ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Drill Holes ☐	Weld ☐	Finish ☐	Material ☐	Marks/Chatter ☐	Fit/Function ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Product Improvement ☐	Mislabeled ☐		Out of Sequence ☐	Misread ☐	Process Improvement ☐			Off-set/Set-up ☐		Human Factors ☐					
Operator ☐	Bending ☐	BOM/Route ☐	Process/Surge ☐	Positioned Wrong ☐																																									
Manufacturing Process ☐	Crushing ☐	Broken/Damage/Defect ☐	Program ☐	Outside Tolerance ☐																																									
Equip/Tooling ☐	Cracks ☐	Incomplete/Unclear Instructions ☐	Direction ☐	Drawing ☐																																									
Handling/Preservation ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Drill Holes ☐	Weld ☐	Finish ☐																																									
Material ☐	Marks/Chatter ☐	Fit/Function ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																									
Product Improvement ☐	Mislabeled ☐		Out of Sequence ☐	Misread ☐																																									
Process Improvement ☐			Off-set/Set-up ☐																																										
Human Factors ☐																																													

DART AEROSPACE
 Container No: S140509
 Part: DSI 9815-011
 Job No: 187928
 Serial No/Batch: S140509
 Revision: A
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH14-14- Issue 2, FAA STC SR03531
 Dart Aerospace Ltd.
 1270 Aberdeen Street
 Haverbury, ON K6A 1K7
 CANADA
 TEL: 1 813 832-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
120	QC 4	15 pcs	12/31/18	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130	Packaging 3-1 - Stock - B4B	15 pcs	12/31/18	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135	DC - 1 - B4B	15 pcs	12/31/18	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
140	QC 21 - FG	15 pcs	12/31/18	0.00 0.00	QC 21 - FG - 21	
Part Op 110 - (Pick Kit) Descriptions: 120 - (QC4- 100% Inspect kits for completeness) 130 - Identify and pack for shipping as per PPP DSI 9815-011 Location: _____ 135 - Photocopy blue file and create labels as per PPP DSI 9815-011 chg 001 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
AN4-5A	Bolt	60 Ea (4 ea)	110-Packaging 1 - Pick Kit	5089332		
D5713-041	Receptacle Assembly	60 pcs (4 ea)	110-Packaging 1 - Pick Kit	5140429		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Plex 12/21/18 9:04 AM Dart.lajeunesse.marie

MS20426AD3-5	Rivet	120 Ea (8 ea)	110-Packaging 1 - Pick Kit	44533	5093756
NAS1149D0432J	Washer	60 Ea (4 ea)	110-Packaging 1 - Pick Kit		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Packaging 1 - Pick Kit	AN4-5A	60	152	0	
	D5713-041	60	0	0	
	MS20426AD3-5	120	1,747	0	
	NAS1149D0432J	60	744	0	
Part Specifications					
Specifications could not be found.					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-822 REV. H AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-822 REV. 6 OR LATER APPROVED REVISION

REF. TCCA STC: SH14-14
REF. FAA STC: SR03538NY
REF. ANAC STC: 2014S07-11
REF. JCAB STC: STC-372-OSA/STC-371-OSA
REF. EASA STC: 10056574

PHOTOCOPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187928MLC
(18122)

1.0 PURPOSE

The purpose of this Service Instruction is to facilitate the replacement of the QD3072-46 Receptacles that are installed on the QB21308 Assembly Screen manufactured by Pall Aerospace as part of the D350-822-011/-013 PA100 PUREair System with the DSI 9815-011 Replacement Receptacle kit. The intent of this DSI has been incorporated into D350-822-011 at CHG 005 and D350-822-013 at CHG 003.

2.0 PROCEDURE

2.1 To install the DSI 9815-011 Replacement Receptacle Kits,

- 2.1.1 Open or remove the Upper Engine Cowl per the Aircraft Maintenance Manual.
 - 2.1.2 Remove the Air Intake Seal and the entire QB21308 Assembly Screen by removing qty(22) fasteners per the Aircraft Maintenance Manual. Retain Hardware.
 - 2.1.3 Separate the FOD screen from the QB21496 Receptacle by turning the 1/4 turn fasteners and lift the FOD screen per Figure 1.
 - 2.1.4 Drill out the retaining rivets and remove qty(4) QD3072-46 Receptacles from the QB21496 Receptacle. Remove any adhesive residue.
 - 2.1.5 Position the qty(4) D5713-041 Receptacle Assy in the location shown in Figure 2. Transfer drill 2x $\varnothing 0.098$ " holes with CSK $\varnothing 0.179$ " $\angle 100^\circ$ on the top side from the D5713-041 Receptacle Assy to the QB21496 Receptacle. Touch up holes with Alodine 1200 per MIL-C-5541.
 - 2.1.6 Mask nutplate holes and touch up the affected areas with prime and paint per ICA-D350-822.
 - 2.1.7 Install qty(4) D5713-041 Receptacle Assy with qty(2) MS20426AD3-(5) Rivets per Figure 2.
- NOTE: Although not generally necessary, it is acceptable to use longer or shorter MS20426AD3-X Rivets
- 2.1.8 Remove qty(4) 1/4 Turn Fasteners from the FOD Screen per Figure 1.
 - 2.1.9 Reinstall the FOD screen on the QB21496 Receptacle using qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 2. Torque bolts to 50-70 in-lb (5.6-7.9 N-m).
 - 2.1.10 Ensure the Engine Intake is clear.
 - 2.1.11 Reinstall the QB21308 Assembly Screen between the Engine Intake Duct and the Air Intake Seal using qty(22) fasteners retained at step 2.1.2 per the Aircraft Maintenance Manual.
 - 2.1.12 Reinstall the Upper Engine Cowl per the Aircraft Maintenance Manual.
 - 2.1.13 Update the Aircraft Log Book to indicate installation of the DSI 9815-011 Replacement Receptacle Kit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 18.12.10
CERT. NO.: SH14-14
ISSUE NO.: 2

APPROVED

A	NEW ISSUE	VS	18.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9815	SHEET 1 OF 4
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	REPLACEMENT RECEPTACLE	NTS
DATE	18.12.10	COPYRIGHT © 2018 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2.2 To remove the FOD screen,

2.2.1 Open Upper Engine Cowl.

2.2.2 Remove qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 3 and remove the FOD screen.

2.3 Reinstallation of FOD screen,

2.3.1 Ensure the Engine Intake and FOD Screen are clear.

2.3.2 Install the FOD Screen with qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 2.

2.3.3 Close Upper Engine Cowl.

3.0 WEIGHT AND BALANCE

The installation of the DSI 9815-011 Replacement Receptacle Kit has negligible effect on Weight and Balance

4.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9815-011	REPLACEMENT RECEPTACLE KIT
4	D5713-041	RECEPTACLE ASSY
4	AN4-5A	BOLT
8	MS20426AD3-5	RIVET
4	NAS1149D0432J	WASHER

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VS	
CHECKED	WK	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9815 SHEET 2 OF 4
APPROVED	VS	TITLE SCALE
DE APPR.	DS	REPLACEMENT RECEPTACLE NTS
DATE	18.12.10	COPYRIGHT © 2016 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

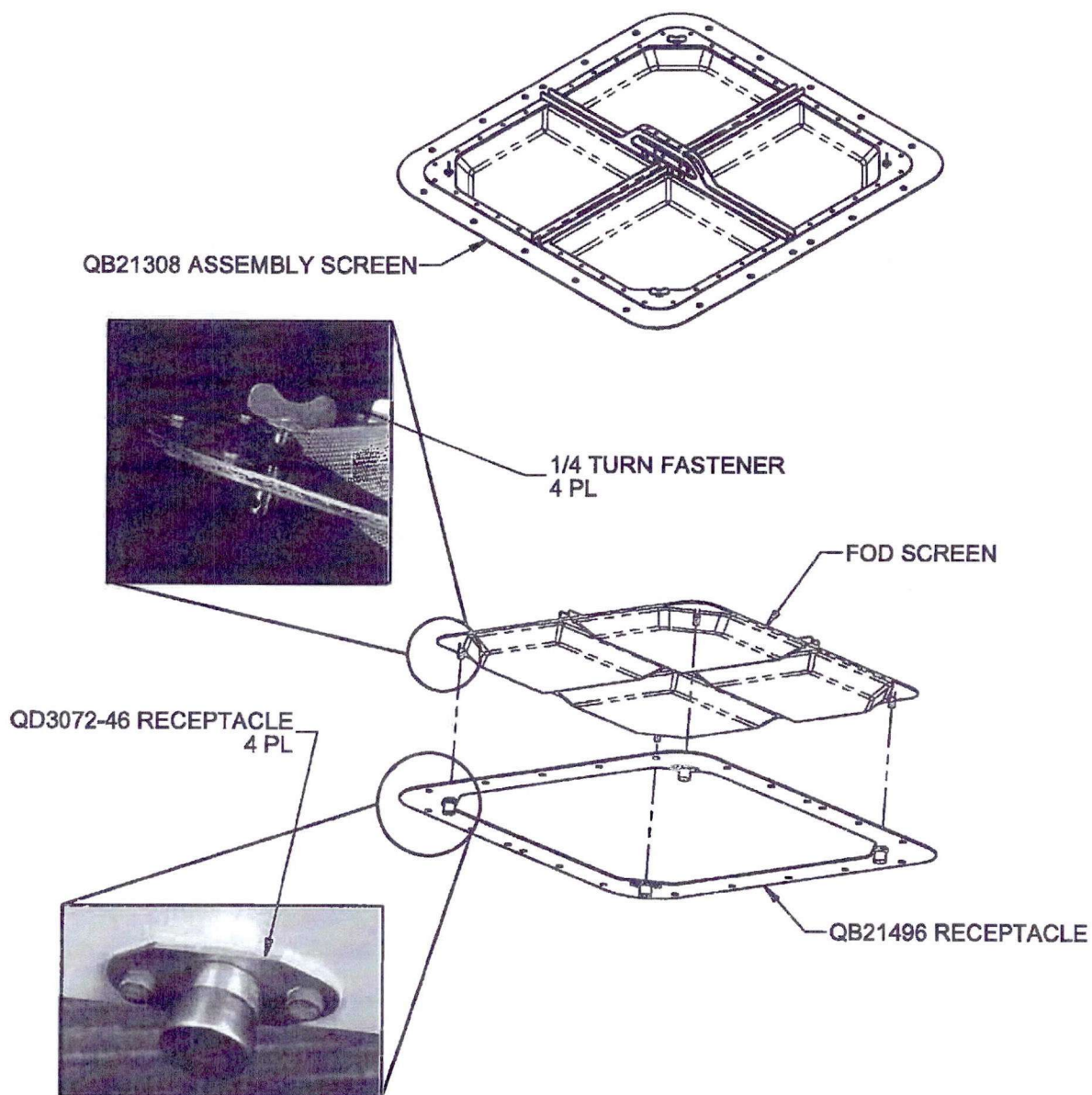


Figure 1 - QB21308 Assembly Screen

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	WK
MFG. APPR.	N/A
APPROVED	VS
DE APPR.	DS
DATE	18.12.10

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
DSI 9815

REV. A

SHEET 3 OF 4

TITLE
REPLACEMENT RECEPTACLE NTS

COPYRIGHT © 2016 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

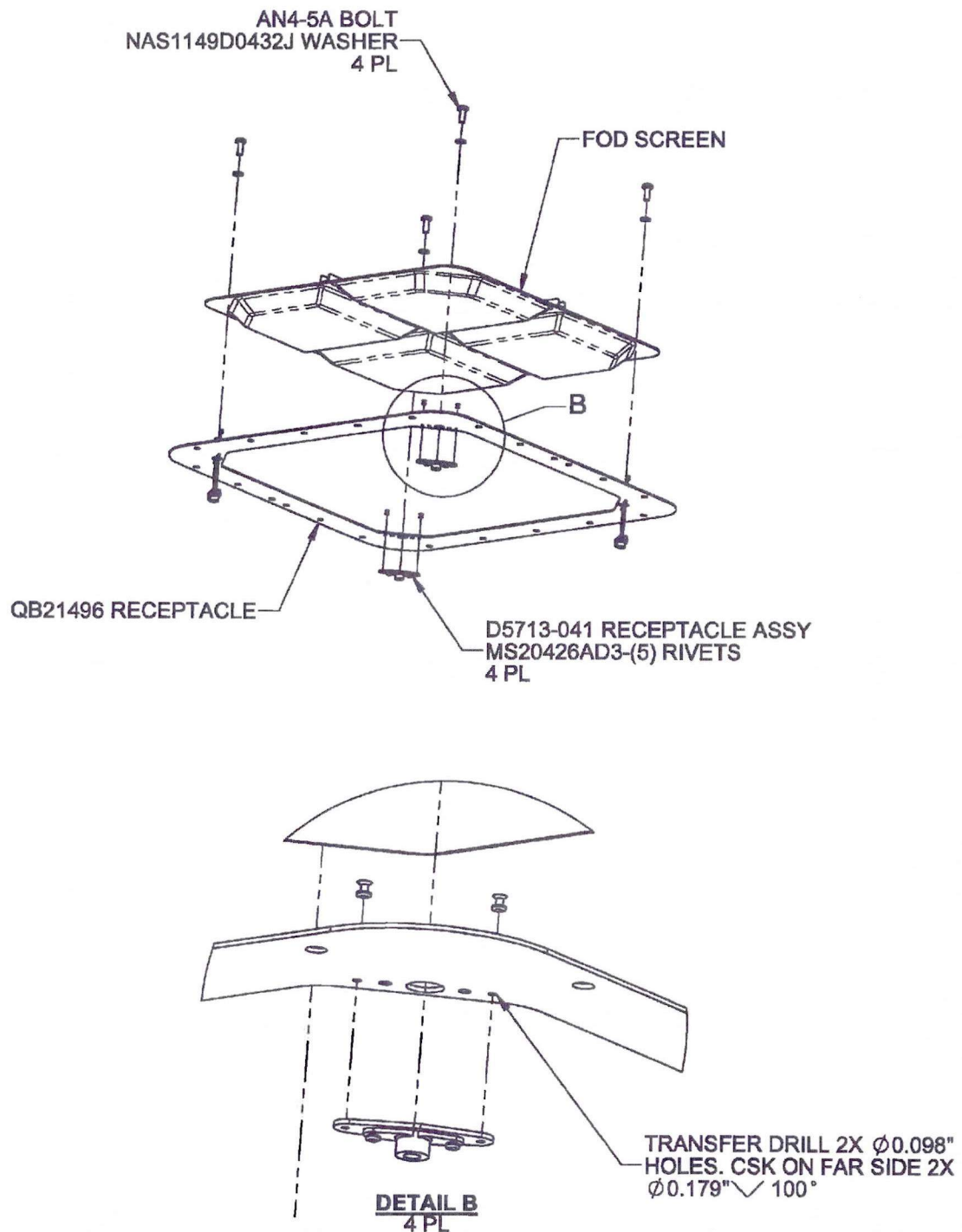


Figure 2 - DSI 9815-011 Replacement Receptacle Kit

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9815	SHEET 4 OF 4
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	REPLACEMENT RECEPTACLE	NTS
DATE	18.12.10	COPYRIGHT © 2018 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	